



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2345
Job Sheet 185892



Part No: D2345

Job Qty: 10 ea

Part Name: Lock Channel



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/6/18

Job Tracking No:

Due Date: 11/27/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPPRevB 99.05.31 Re-format DM IPP Rev:C Now on Waterjet 06-10-26 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	10 pcs		11/27/18	0.00	0.72	Waterjet - Flow		SC 18/11/07
120	QC	10 pcs		11/27/18	0.00	0.00	QC8		38
130	Small Fab	10 pcs		11/27/18	0.00	0.70	Small Fab		1-89
140	Brake NC	10 pcs		11/27/18	0.00	0.67	Brake NC 1	N/A	DAS
150	QC	10 pcs		11/27/18	0.00	0.00	QC5		NOV 16 2018 68
160	Packaging	10 pcs		11/27/18	0.00	0.00	Packaging3		9-89
170	QC21-SA	10 Ea		11/27/18	0.00	0.00	QC21		DAS NOV 22 2018

Part Op 100 - 1-Cut as per Dwg D2345

Descriptions: 130 - Deburr if necessary.

140 - Form as per Dwg D2345 using DT8241 Remove tooling tab and buff flush

160 - LOCATION : GA

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	.5280 sf (.0528 ea)	100-Waterjet - Flow - 1	5055089

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S18GA	1	333	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Lock Channel	2.800Inches $\pm$ 0.010	2.810 2.790	2.80	
2	Lock Channel	2.520Inches $\pm$ 0.010	2.530 2.510	2.518	
3	Lock Channel	0.094Inches + 0.004 - 0.001	0.098 0.093	0.095 Diameter	
4	Lock Channel	0.478Inches $\pm$ 0.010	0.488 0.468	0.480	
5	Lock Channel	1.256Inches + 0.005 - 0.001	1.261 1.255	1.256	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Suspect ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Cross tube ☐ Small Fab ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		Part: D2345 Job No: 185892 Serial No/Batch: S125287 Container No: S125287 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 11/07/18					
Description Work Order Deviation									
Root Cause <table style="width: 100%;"> <tr> <td style="width: 50%;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width: 50%;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table style="width: 100%;"> <tr> <td style="width: 50%;"> Pressure/Fo ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width: 50%;"> Setup ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> </tr> </table>				Pressure/Fo ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Setup ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐
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6	Lock Channel	0.197Inches $\pm$ 0.010	0.207 0.187	0,197 Diameter
7	Lock Channel	2.750Inches $\pm$ 0.010	2.760 2.740	2,748
8	Lock Channel	3.000Inches $\pm$ 0.010	3.010 2.990	3,002
9	Lock Channel	0.050Inches $\pm$ 0.010	0.060 0.040	0,046

Plex 11/6/18 11:29 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____	